Work Order ID 95270

95270

January-07-13 10:34:17 AM

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 1/07/13 **Start Qty:** 10.00 *10* **Cust Item ID:**
Required Date: 1/25/13 **Req'd Qty:** 10.00 *10* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** [signature] **Date:** 13-01-7 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2661	Rev E								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1		[signature] 13-03-24			10	Ø		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071 FOLIO REV: AA DWG REV: E								
110		0.00							
110	CONVENTIONAL MILLING MACHINE		[signature] 13-03-24			10	Ø		
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								

PTO

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [illegible] Date: 13/04/16

QA Closed: CK Date: 13/4/12

Work Order: 95270

Part No. D2661-2

NCR No. 13-2492

DISPOSITION

Rework	
Scrap	
Use-as-is	X
Work Order Update	

AGAINST DEPARTMENT/PROCESS

Skid-tube		Crosstube		Water Jet		Engineering	
Machining	/	Small Fab		Prod. Eng. Coor.		Quality	
Thermoforming		Finishing		Rec/Store/Packaging		Other	
Large Fab		Composite		Supplier			

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data		13/3/28	100	1	Saddle-to-skid holes over over tolerance in relation to [illegible] groove. R.L setup was wrong for	[signature] 13/4/16	Acceptable. Test fit on skid is OK	[signature] 13/3/28	DAS 33 13-03-28	DAS 16 Bloulos
Equip/Tooling										
Operator										
Material										
Setup	X									
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- Bending
- Centre Not Concentric to O/S
- Cracks
- Crushed/Crimped
- Cuffs
- Heat Treat
- Inspection Strip in Tube
- Ripples in Bend
- Torque Waves in Extrusion
- Turning Sequence
- Wave/Twist in Tube

General

- Bend
- BOM/Route
- Broken/Damaged
- Burrs
- Contamination
- Countersink
- Cut Too Short
- Drill Holes
- Drawing
- Finish
- Folio
- Grain
- Hardware
- Inspection Incomplete
- Instructions Incomplete/Unclear
- Maintenance
- Mislabeled
- Misread
- Offset
- Out of Calibration
- Out of Sequence
- Outside Dimensions
- Ovalized
- Over/Under tolerance
- Part Incorrect
- Part Lost/Missing
- Part Moved
- Positioned Wrong
- Power Loss/Surge
- Pressure/Forced
- Temperature/Cure
- Weld
- Wrong Stock Pulled
- Other

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 1/07/13 **Start Qty:** 10.00 *10*
Required Date: 1/25/13 **Req'd Qty:** 10.00 *10*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120			13-03-24			10	0		
QC	**Memo**	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130						10	0		DAS 33 13.03.28
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						10	13 42		
HandFinish	**Memo**	0.00							
Hand Finishing									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 1/07/13 **Start Qty:** 10.00 *10*
Required Date: 1/25/13 **Req'd Qty:** 10.00 *10*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150 Powdercoat Powder Coating	**Memo** START TIME: 8:30 FINISH TIME: 9:00 OVEN TEMPERATURE: 325°F	0.00							
160	QC3- Inspect Part Finish	0.00							
160 QC Quality Control	**Memo**	0.00							
170	Identify as per dwg & Stock Location:_____	0.00							
170 Packaging Packaging	**Memo** 5732	0.00							

M124245

10x 13/04/03

10x 13/04/03

13/04/03 (10)

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 95270

95270

January-07-13 10:34:17 AM

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 1/07/13 **Start Qty:** 10.00 *10* **Cust Item ID:**

Required Date: 1/25/13 **Req'd Qty:** 10.00 *10* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	**Memo**	0.00							
Quality Control									

13/4/4

RLB-04-4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

January-07-13 10:34:17 AM

Work Order ID: 95270

Parent Item: D2661-2

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 1/07/13 **Required Date:** 1/25/13

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM
IPP REV:D REDESIGN PER ENG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075		Manufactured	No			100	Each	29.0000	1 10	**10**		13-03-24	

Location	Loc Qty	Loc Code	
MAT042	29		
91238	19		
92531	2		
93319	8		
97563			10

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Work Order Update	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐
Large Fab	☐	Composite	☐	Supplier	☐
Engineering	☐				
Quality	☐				
Other	☐				
	☐				

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric to O/S
☐	Cracks
☐	Crushed/Crimped
☐	Cuffs
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Ripples in Bend
☐	Torque Waves in Extrusion
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damaged
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drill Holes
☐	Drawing
☐	Finish
☐	Folio

☐	Grain
☐	Hardware
☐	Inspection Incomplete
☐	Instructions Incomplete/Unclear
☐	Maintenance
☐	Mislabeled
☐	Misread
☐	Offset
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions

☐	Ovalized
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge

☐	Pressure/Forced
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☐	Other

_____

_____

_____

DART AEROSPACE LTD	Work Order:	95270
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	3.611	3.621		3.614	3.6135	3.613	3.614	3.614
B	0.256	0.263		.259	.259	.259	.259	.259
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.497	2.499	2.497	2.498	2.498
E	1.674	1.684		1.6785	1.679	1.6785	1.6795	1.6778
F	1.357	1.367		1.3605	1.360	1.3615	1.3605	1.361
G	0.100	0.140		.119	.120	.120	.120	.120
H	0.210	0.230		.225	.224	.224	.224	.225
I	0.615	0.685		.665	.665	.665	.665	.665
J	2.470	2.510		2.488	2.490	2.490	2.490	2.490
K	1.313	1.343		1.326	1.328	1.328	1.328	1.328
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1347	1.1353	1.1339	1.1353	1.1356
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.128	.124	.126	.125	.123
Q	0.240	0.260		.253	.252	.252	.252	.253
R	0.677	0.697		.684	.6865	.6875	.6875	.686
S	0.100	0.140		.121	.118	.118	.117	.117
T	1.565	1.585		1.5748	1.5754	1.574	1.5752	1.5754
U	0.540	0.560		.548	.5465	.549	.5495	.5485
V	0.912	0.932		.924	.9205	.9255	.925	.9245
W	0.787	0.807		.7935	.7945	.7935	.7935	.792
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		4.997	4.996	4.997	4.997	4.997
Z	0.490	0.510		.499	.500	.500	.497	.5025
AA	0.312	0.319		.313	.313	.313	.313	.313
AB	0.990	1.010		1.003	1.003	1.003	1.003	1.003
AC	1.245	1.255		1.248	1.2475	1.247	1.248	1.248
AD	0.490	0.510		.502	.5025	.5025	.503	.500
AE	3.745	3.755		3.748	3.7485	3.749	3.748	3.748
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.513	.513	.513	.513	.513
AH	0.100	0.120		.116	.116	.116	.116	.116
			Accept/Reject					

Measured by:	JJ	**Date:**	13-03-23
Audited by:	BC	**Date:**	13-03-24
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	95270
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

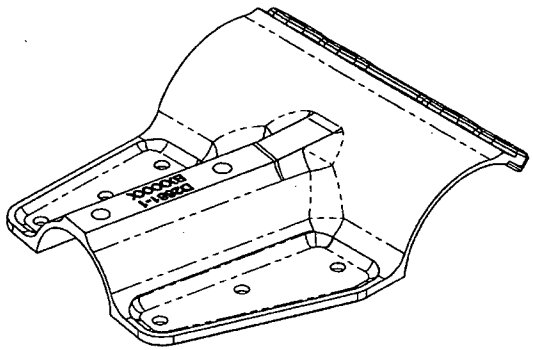
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	3.611	3.621		3.613	3.613	3.613	3.614	3.613
B	0.256	0.263		.259	.259	.259	.259	.259
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.497	2.497	2.498	2.498	2.497
E	1.674	1.684		1.680	1.6785	1.6785	1.678	1.678
F	1.357	1.367		1.3605	1.362	1.360	1.362	1.3625
G	0.100	0.140		.120	.120	.120	.120	.120
H	0.210	0.230		.223	.224	.224	.224	.225
I	0.615	0.685		.665	.665	.665	.665	.665
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.328	1.328	1.328	1.328	1.328
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1355	1.1354	1.1356	1.1368	1.1365
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.122	.122	.122	.122	.122
Q	0.240	0.260		.254	.252	.252	.253	.252
R	0.677	0.697		.6875	.689	.689	.688	.689
S	0.100	0.140		.118	.118	.116	.118	.117
T	1.565	1.585		1.5756	1.5758	1.5758	1.5768	1.5767
U	0.540	0.560		.5495	.549	.549	.549	.549
V	0.912	0.932		.923	.925	.925	.925	.9245
W	0.787	0.807		.7915	.7915	.7915	.791	.791
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		4.998	4.997	4.998	4.998	4.998
Z	0.490	0.510		.497	.499	.499	.499	.498
AA	0.312	0.319		.313	.313	.313	.313	.313
AB	0.990	1.010		1.003	1.003	1.003	1.003	1.003
AC	1.245	1.255		1.248	1.248	1.248	1.248	1.248
AD	0.490	0.510		.502	.503	.502	.5015	.502
AE	3.745	3.755		3.748	3.748	3.748	3.748	3.748
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.513	.513	.513	.513	.513
AH	0.100	0.120		.116	.116	.116	.116	.116
							E	
			Accept/Reject					

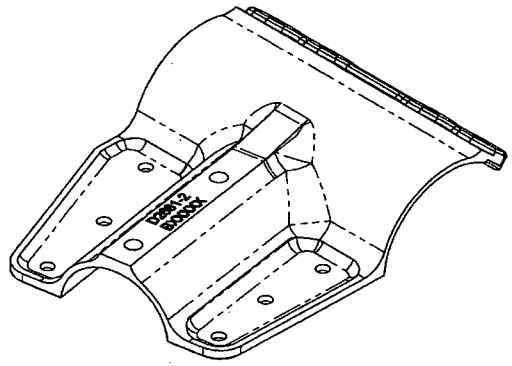
Measured by:	[signature]	**Date:**	13-03-24
Audited by:	BG	**Date:**	13.03.28
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	[signature]

95270
11/13-01-7



D2661-1 SADDLE, OUTSIDE, LH



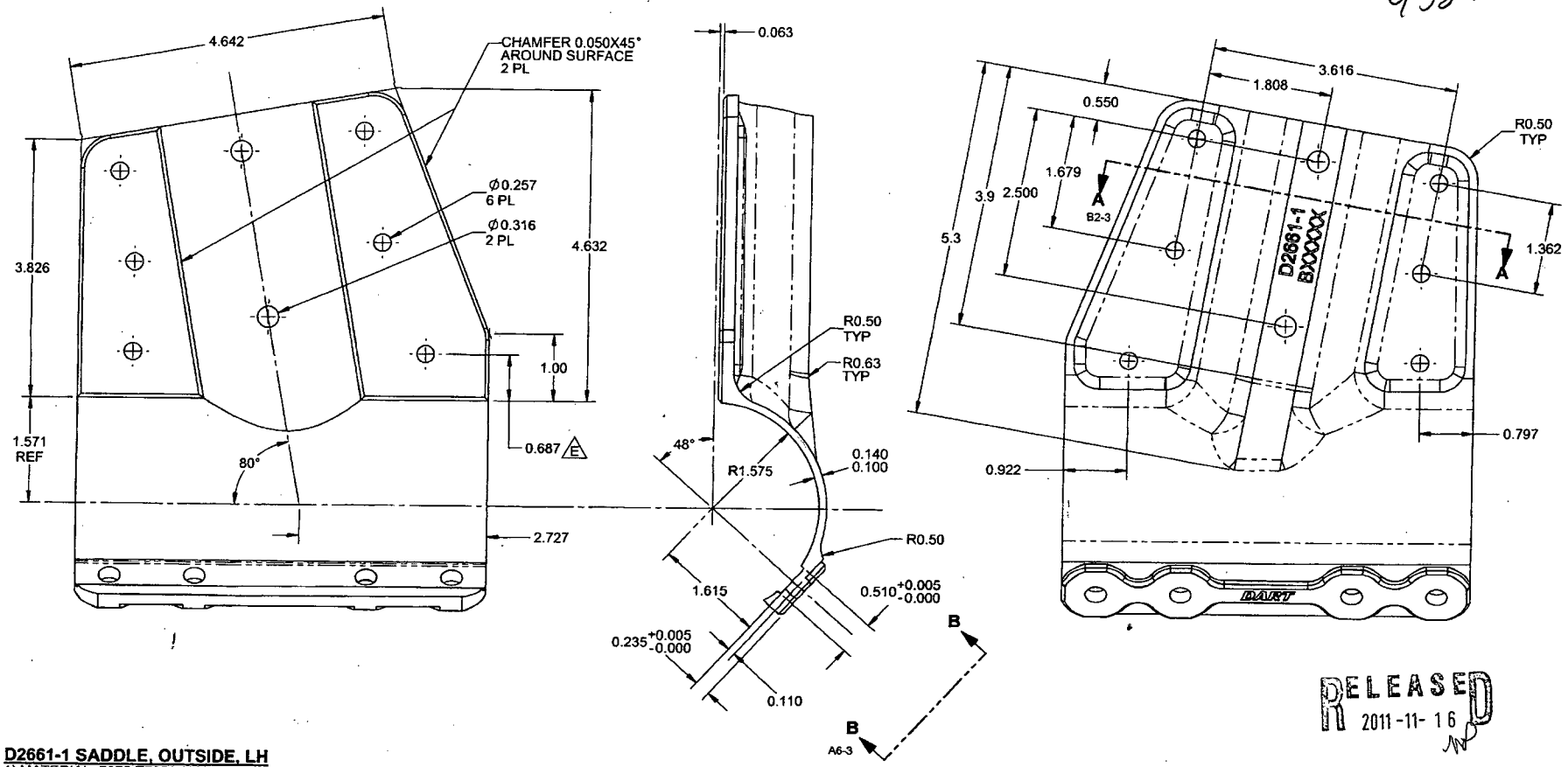
D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE	11.10.31	

95270



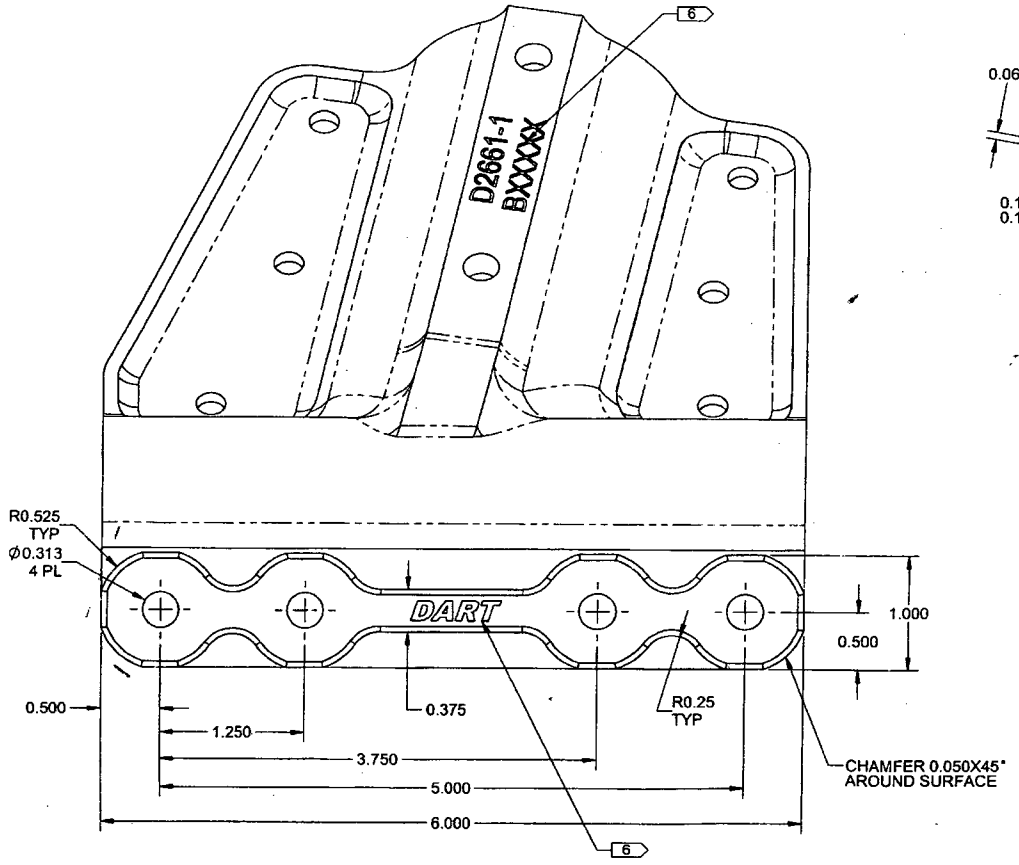
RELEASED
2011-11-16

D2661-1 SADDLE, OUTSIDE, LH

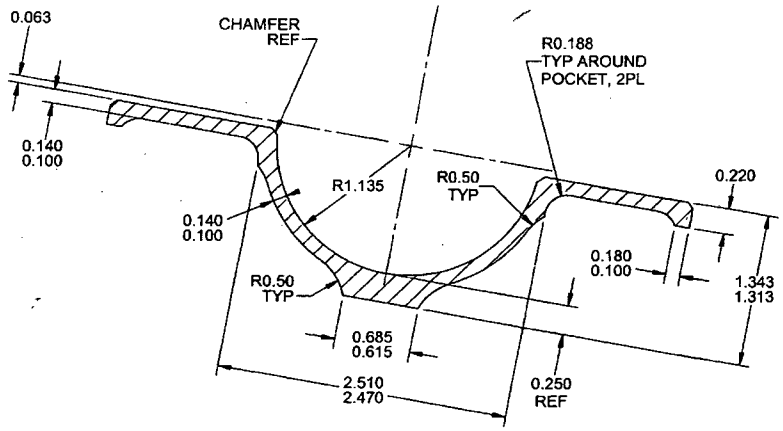
1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED	ASS	DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		

95270



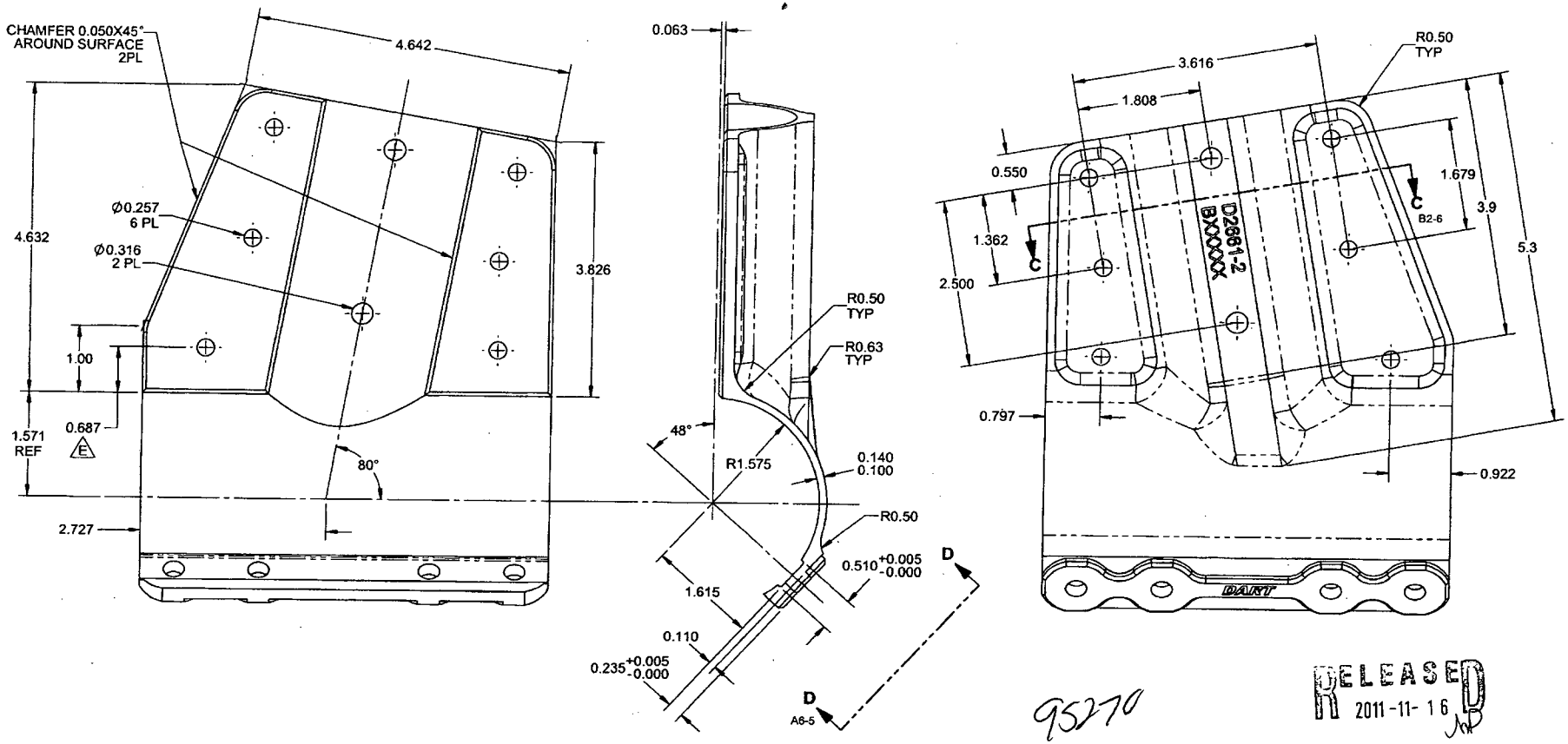
VIEW B-B A4-2
SCALE 1.5X
VIEW ROTATED



VIEW A-A C3-2
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		DRAWING NO. D2661 — REV. E — SHEET 3 OF 5
CHECKED		TITLE: SADDLE, OUTSIDE — SCALE: NTS
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.10.31	



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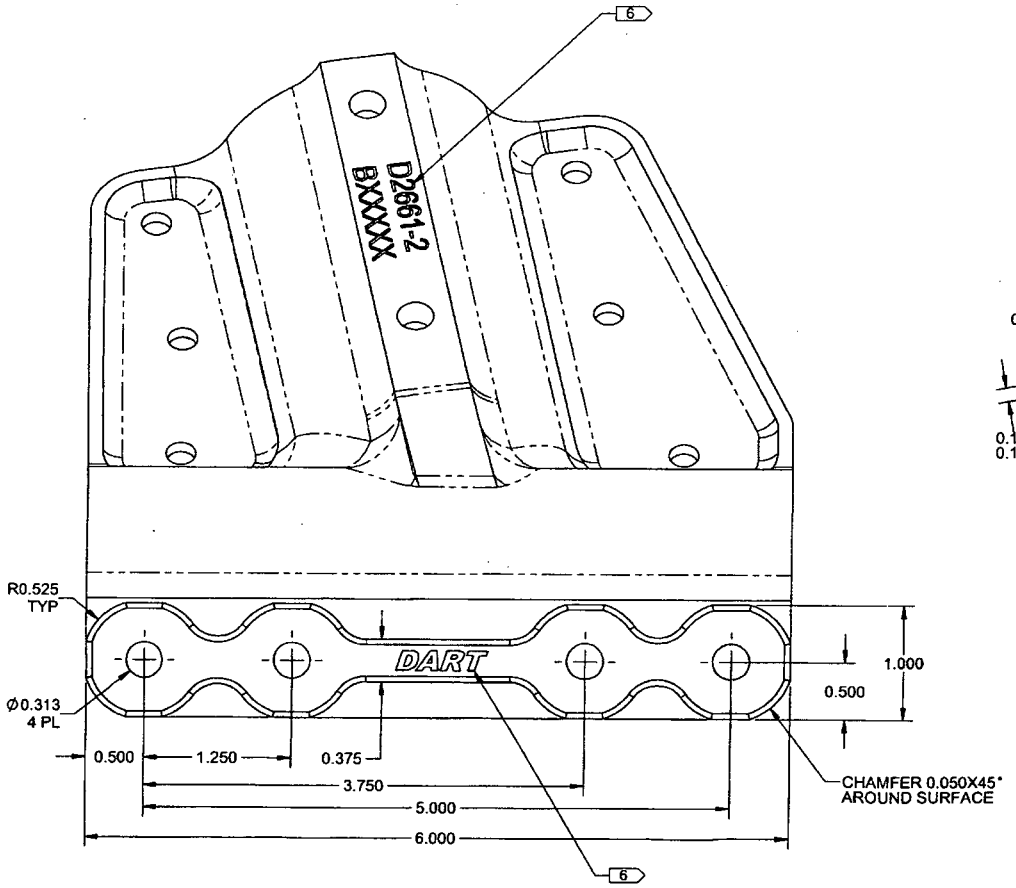
RELEASED
2011-11-16

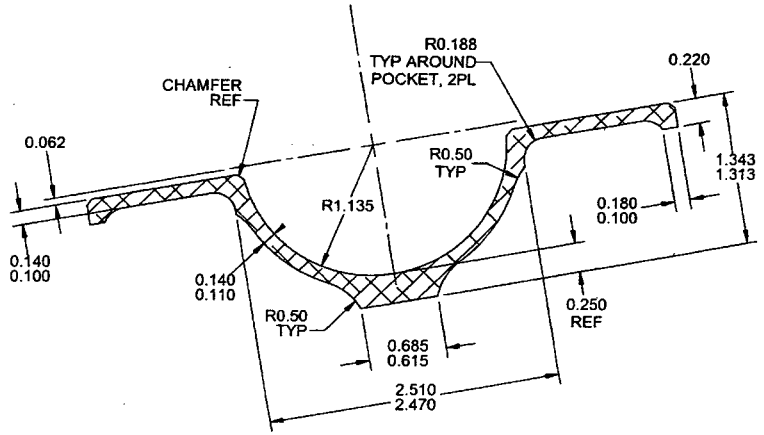
D2661-2 SADDLE, OUTSIDE, RH

1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED	ASS	DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

95270

RELEASED
2011-11-16

DESIGN		**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		DRAWING NO. D2661 — REV. E — SHEET 5 OF 5
CHECKED		TITLE: SADDLE, OUTSIDE — SCALE: NTS
MFG. APPR.		
APPROVED		
DE APPR.		
DATE 11.10.31		